



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3391-021
Job Sheet 171907



Part No: D3391-021

Job Qty: 1 ea

Part Name: Fwd Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/9/18

Job Tracking No:

Due Date: 2/26/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG D3391 REV J SHEETS 4,5 IPP A 05.09.13 New issue KJ/JLM IPP B IPP C IPP D 07.03.13 rev F dwg EC IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD IPP Rev:f ECN 1056 07-11-12 DD verified by: EC IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC IPP Rev I 09.02.02 added hardware EC verified by: DD IPP Rev:J 11.11.14 AS PER REV.I DD verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	2/23/18	2/23/18	0.00	0.00	Start Up Skid tubes-1		
100	Skid tubes	1 pcs	2/23/18	2/23/18	0.00	0.82	Skid tubes-4		M.G.
110	CNC Bend Skid tubes	1 pcs	2/24/18	2/24/18	0.00	1.00	CNC Bend Skid tube		M.G.
120	QC	1 pcs	2/24/18	2/24/18	0.00	0.00	QC5		DE
130	CNC Vertical Machining	1 pcs	2/24/18	2/24/18	2.21	1.00	HAAS1-3		SC 1802/17
140	QC	1 pcs	2/24/18	2/24/18	0.00	0.00	QC2 Machining-2		SC 1802/17
150	Mill Conv	1 pcs	2/24/18	2/24/18	0.00	0.27	Mill Conv 1		SC 1802/17
160	QC	1 pcs	2/24/18	2/24/18	0.00	0.00	QC2 Machining-2		SC 1802/17
170	QC	1 pcs	2/24/18	2/24/18	0.00	0.00	QC8 Machining-2		SC 1802/17
180	Skid tubes	1 pcs	2/24/18	2/24/18	0.00	0.82	Skid tubes-4		J.G. DAS 38
190	QC	1 pcs	2/24/18	2/24/18	0.00	0.00	QC5		18-02-22
200	HandFinish	1 pcs	2/24/18	2/24/18	0.00	0.33	HandFinish1		18-02-22
210	QC	1 pcs	2/24/18	2/24/18	0.00	0.00	QC7-2		M.G.
220	Skid tubes	1 pcs	2/24/18	2/24/18	0.00	0.82	Skid tubes-4		M.G.
230	QC	1 pcs	2/24/18	2/24/18	0.00	0.00	QC5		18-02-23
235	HandFinish	1 pcs	2/24/18	2/24/18	0.00	0.33	HandFinish2		18-02-23
241	SprayPaint	1 pcs	2/24/18	2/24/18	0.00	0.99	Spray Paint		18-02-23
250	QC	1 pcs	2/24/18	2/24/18	0.00	0.00	QC14		18-02-23
254	HandFinish	1 pcs	2/26/18	2/26/18	0.00	0.33	HandFinish4		18-02-23
256	QC	1 pcs	2/26/18	2/26/18	0.00	0.00	QC5		18-02-23
260	Packaging	1 pcs	2/26/18	2/26/18	0.00	0.00	Packaging3-1		18-02-23
280	QC21-SA	1 Ea	2/26/18	2/26/18	0.00	0.00	QC21		18-02-23

Part Op 100 - Cut as per dwg.

Descriptions: 110 - Bend as per Dwg D3391 Using Bend Prog 3391021

130 - 1-Machine as per Folio FA590 Rev. ____ & Dwg D3391 Rev. ____

150 - Drill X1 Aft cap as per Dwg D3391 .1875" dia

180 - 1-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step 2-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size) (ONLY DRILL HOLES MARKED "A") 6-Deburr & Scribe Batch number inside aft end. 7-Transfer drill D3391-021 with D3391-023

220 - 1-instal spacers as per dwg D3391 A/R Magnabond 6398 batch: M37073 exp. date: 02-18 cure time 12hrs. as per QSI015 2- grind crossbolt flush 3-back drill crossbolt if necessary

235 - AND REALODINE AS PER QSI 005

Prime 137670
Paint 138741

Plex 2/9/18 10:21 AM Dart.Gagnon.Michelle

5042030

DART
AEROSPACE
S042030

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Fwd Tube Assembly

PART NO: D3391-021

Original Serial #: S042030

Revision:

Operation:

Change No:

Start up Operation

02/13/18

Job No: 171907

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6013-047 <i>B86064</i>	Skidtube Material	1 Ea (1 ea)	90-Start up Operation	
D3670-4-200	Bushing	4 Ea (4 ea)	220-Skidtubes	
AELS-1032-225	Insert	10 Ea (10 ea)	254-HandFinish	
AN3C4A	Bolt	10 Ea (10 ea)	254-HandFinish	
D3401-041	Tow Cap Assembly	1 Ea (1 ea)	254-HandFinish	
D3672-1	Washer, Phenolic	4 Ea (4 ea)	254-HandFinish	
D4095-051	Wearpad Fwd	1 Ea (1 ea)	254-HandFinish	
NAS1149C0332R	Washer	10 Ea (10 ea)	254-HandFinish	

Job Allocations <i>001163</i>				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6013-047	1	53	0
220-Skidtubes	D3670-4-200 <i>5021404</i>	4	58	0
254-HandFinish <i>5007280</i>	AELS-1032-225 <i>ABSH</i>	10	0	0
	AN3C4A <i>501939W</i>	10	1,922	0
	D3401-041 <i>F155540</i>	1	2	0
	D3672-1 <i>F150071</i>	4	1,095	0
	D4095-051 <i>M1159902-127</i>	1	28	0
	NAS1149C0332R <i>5019380</i>	10	2,511	0

Part Specifications				
Specifications could not be found.				

Plex 2/9/18 10:21 AM Dart.Gagnon.Michelle

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
4 PL

DETAIL B



INSTALL
AELS-1032-225
AFTER FINISH
10 PL

D4095-051
WEARSHOE

AN3C4A BOLT
NAS1149C0332R WASHER
6 PL

D3391-021 FWD TUBE ASSEMBLY ASSEMBLY DETAIL

SEAL WITH
SIKAFLEX-241/-291

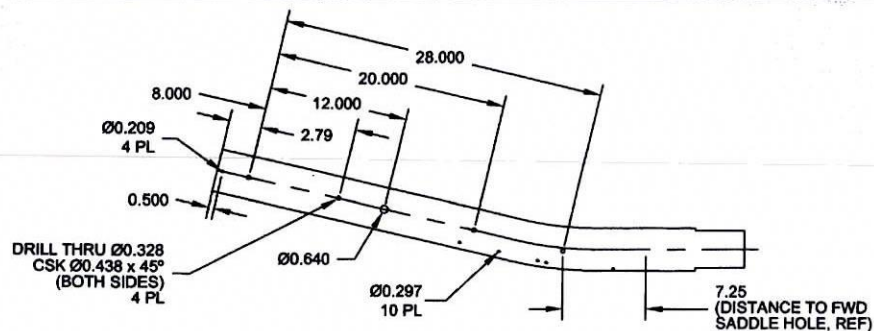
D3401-041
TOW CAP

DETAIL B SCALE 2X

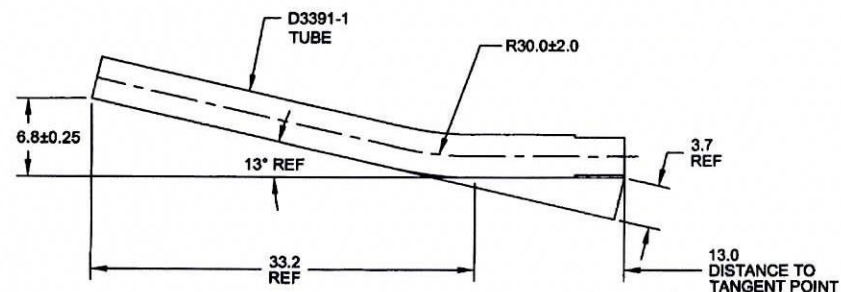
AN3C4A BOLT
D3672-1 WASHER
NAS1149C0332R WASHER
4 PL

D3391-021 FWD TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-021	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
4	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER



D3391-021 DRILLING DETAIL



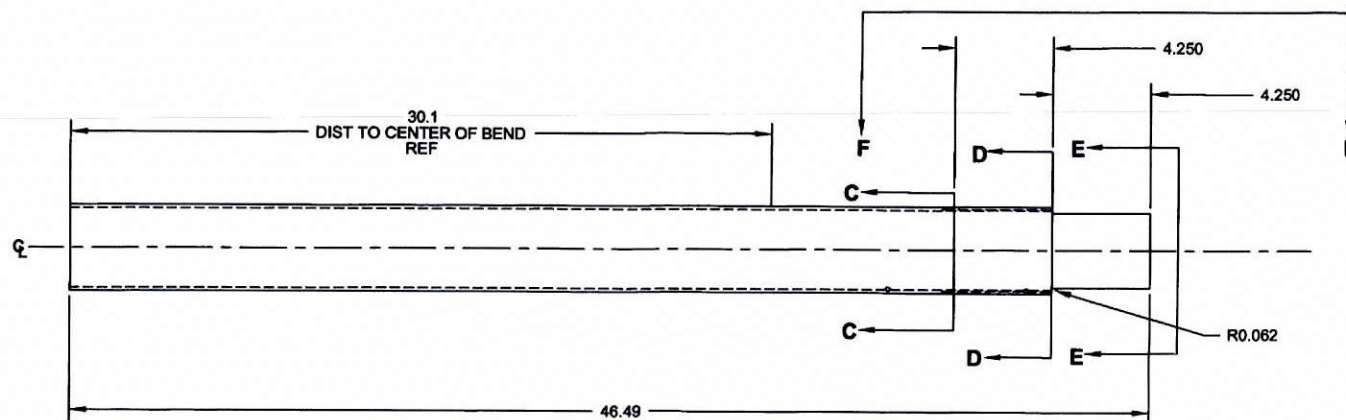
D3391-021 BENDING DETAIL (MAKE FROM D3391-1)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171907

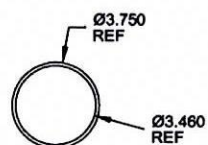
FEB 09 2018

RELEASED
2016-04-28

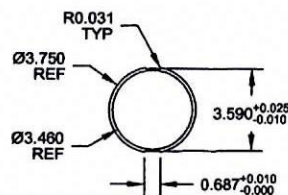
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	DE	D3391	SHEET 4 OF 11
APPROVED	DE	TITLE	SCALE
DE APPR.	DE	412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



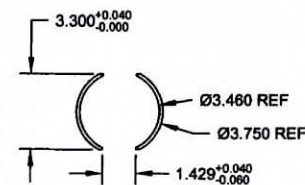
D3391-1 TUBE
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



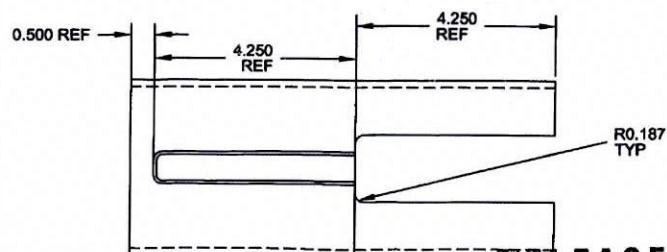
SECTION C-C



SECTION D-D



SECTION E-E



VIEW F-F
SCALE 2X

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2016-04-28

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	22	D3391	SHEET 5 OF 11
APPROVED	22	TITLE	SCALE
DE APPR.	22	412 FLOAT SKIDTUBE	NTS
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